

Work Order ID 61201

Wednesday, August 11, 2010 10:08:25 AM

Page 1

Item ID: D3537-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearpad

Start Date: 8/11/2010 Start Qty: 50.00

Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 50.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-8-11

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 □ Dwg Rev: C □ Prog Rev: C □ 2-Deburr if necessary

304 .063

10-8-18

59

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-8-18

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

60
cancel

100818

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: Wearpad

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Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

EP 10/08/17 (60)

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

R 10-8-31 (x60)

150

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

Solo 10/31

counts (x60)

Dart Aerospace Ltd

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Start Date:	8/11/2010	Start Qty:	50.00		Cust Item ID:	
Required Date:	8/25/2010	Req'd Qty:	50.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				cont (x60)			
170 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 130 320 FINISH TIME: 200	0.00 0.00							in 10 09 01 (60)
180 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							x60 9

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 8/25/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: FP-18

0.00

ju

10/09/01

60

0



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/02

mf 10-9-01

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, August 11, 2010 10:08:25 AM

Page 1
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Work Order ID: 61201



Parent Item: D3537-1



Parent Item Name: Wearpad


Start Date: 8/11/2010

Required Date: 8/25/2010

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA  304/316 Sheet .063		Purchased	No			100	sf	0.0267	0.106	5.578947	6.3	10-8-18	



Location

Loc Qty

Loc Code

MAT

0.026694737

111323

0

114799

0.02669474

115440

115440

59

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	61201
Description: Wearpad		Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.249	X		V IB02	
3.500	+/-0.010	3.496	X		V	
1.965	+/-0.010	1.968	X		V	
2.795	+/-0.010	2.791	X		V	
3.625	+/-0.010	3.622	X		V	
0.220 x 0.380	+/-0.010	0.224 x 0.384	X		V	

Measured by: RB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10-8-18	Date: 10-08-18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
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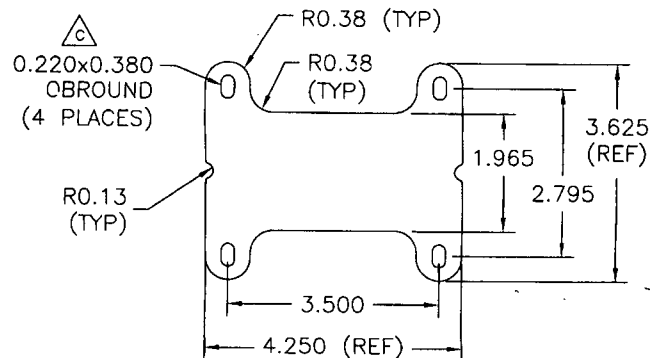
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

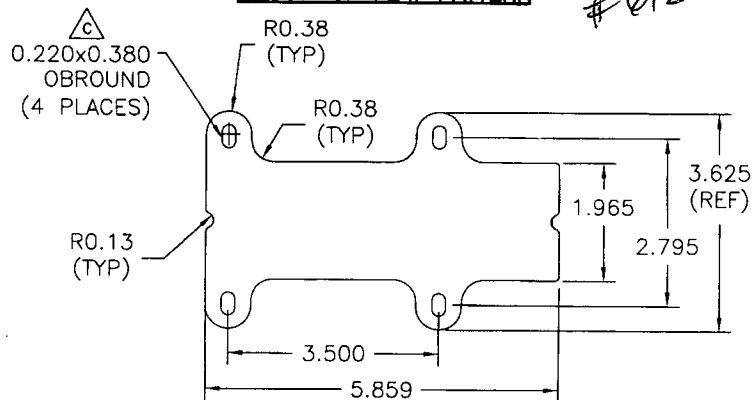
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D3537-1F FLAT PATTERN

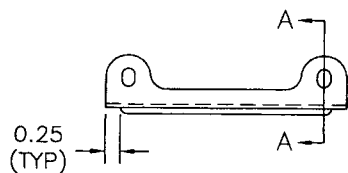


D3537-3F FLAT PATTERN



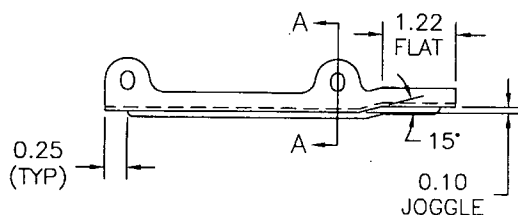
D3537-1 LONGITUDINAL BEND

(MADE FROM D3537-1F)



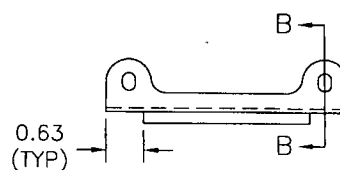
D3537-3 LONGITUDINAL BEND

(MADE FROM D3537-3F)

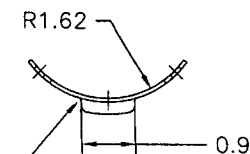


D3537-5 LONGITUDINAL BEND

(MADE FROM D3537-1F)

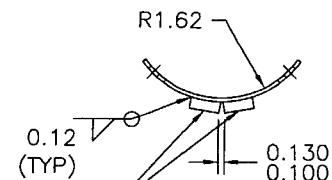


SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

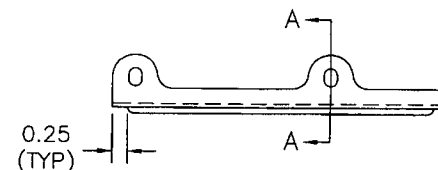
SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND

(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	C B	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	A	APPROVED	A	PORT HADLOCK, MA
DATE	07.04.13	DRAWING NO.	D3537	REV. C
		TITLE	WEARPAD	SHEET 1 OF 1
				SCALE 1:2

RELEASED
07.05.08 PH
per ECN 962

Dart Aerospace Ltd

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